

Date: Friday, 3/16/2007 1:12:57 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
Job Number	: 31250		
Estimate Number	: 10832		
P.O. Number	: N/A	Part Number	: D29322
This Issue	: 3/16/2007 S.O. No. : N/A	Drawing Number	: D2932-UNDER REVIEW C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/16/2007 Type : MACHINED PARTS	Drawing Revision	: B C
Previous Run	: 30485	Material	: N/A
Written By	:	Due Date	: 3/30/2007
Checked & Approved By	: <u>07.03.16</u>	Qty:	8 Um: Each
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.000

D6101003

7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0 x 6.25 X 7.88

Grain Along Long 7.88 Length

Batch No: \_\_\_\_\_

B25349 En 07/03/25 (x8)

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number. En 07/03/25

1-Inspect part number and batch number are programmed correctly. J.F.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 &amp; attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 &amp; attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 &amp; attached Dimension Sheet

5-Deburr

En 07/03/26 (x8)

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

En 07/03/26 (x8)

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

En 07/03/26 (x8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/29

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 3/16/2007 1:12:57 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 31250

Part Number: D29322

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07-03-26

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

07/03/27

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MS

07-03-27 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/03/28 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/03/28 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/29

Job Completion



U 07-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b>	<b>D2932-2</b>
<b>Inspection Dwg:</b> D2932 Rev. <i>EC</i>		<b>Page 1 of 1</b>	

*cb 07.03.16*

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.123	0.119	0.122	0.119		
B	0.100	0.140		0.122	0.119	0.120	0.121		
C	0.100	0.140		0.113	0.114	0.114	0.115		
D	0.210	0.230		0.220	0.218	0.220	0.222		
E	1.245	1.255		1.245	1.245	1.248	1.248		
F	1.245	1.255		1.245	1.245	1.248	1.248		
G	2.495	2.505		2.498	2.500	2.499	2.498		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.575	1.574	1.575	1.576		
J	2.495	2.505		2.496	2.501	2.499	2.498		
K	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
L	0.312	0.317	DT8686	0.315	0.315	0.315	0.315		
M	0.235	0.240		0.240	0.239	0.239	0.239		
N	0.100	0.140		?	?	?	?		
O	0.540	0.560		0.545	0.546	0.543	0.543		
P	0.490	0.510		0.495	0.497	0.496	0.495		
Q	3.715	3.725		3.718	3.719	3.719	3.719		
R	2.470	2.510		2.497	2.496	2.498	2.493		
S	0.240	0.270		0.251	0.253	0.253	0.249		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.626	1.629	1.630	1.626		
V	1.362	1.372		1.364	1.366	1.366	1.364		
W	0.316	0.321	DT8690	0.320	0.320	0.320	0.320		
X	1.125	1.145		1.136	1.133	1.134	1.136		
Y	1.565	1.585		1.574	1.575	1.574	1.576		
Z	0.015	0.035		0.025	0.025	0.025	0.025		
AA	6.990	6.010		6.060	6.001	6.001			
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>En</i>
Date:	<i>07/03/26</i>

Audited by:	<i>3A</i>
Date:	<i>07.03.26</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b>	<b>D2932-2</b>
<b>Inspection Dwg:</b> D2932 Rev. <i>BC</i>			<b>Page 1 of 1</b>

*CB 07.03.16*

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.121	0.119	0.121	0.121		
B	0.100	0.140		0.122	0.121	0.121	0.120		
C	0.100	0.140		0.115	0.116	0.112	0.113		
D	0.210	0.230		0.221	0.219	0.220	0.221		
E	1.245	1.255		1.245	1.247	1.248	1.248		
F	1.245	1.255		1.245	1.247	1.248	1.248		
G	2.495	2.505		2.498	2.498	2.500	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.574	1.576	1.577	1.576		
J	2.495	2.505		2.497	2.497	2.498	2.500		
K	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
L	0.312	0.317	DT8686	0.315	0.315	0.315	0.315		
M	0.235	0.240		0.240	0.246	0.240	0.239		
N	0.100	0.140		?	?	?	?		
O	0.540	0.560		0.545	0.543	0.544	0.544		
P	0.490	0.510		0.493	0.498	0.496	0.495		
Q	3.715	3.725		3.719	3.718	3.719	3.719		
R	2.470	2.510		2.496	2.496	2.498	2.493		
S	0.240	0.270		0.250	0.251	0.249	0.250		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.626	1.628	1.630	1.630		
V	1.362	1.372		1.363	1.366	1.368	1.367		
W	0.316	0.321	DT8690	0.320	0.320	0.320	0.320		
X	1.125	1.145		1.135	1.135	1.136	1.136		
Y	1.565	1.585		1.574	1.575	1.575	1.576		
Z	0.015	0.035		0.025	0.025	0.025	0.025		
AA	6.990	6.010		6.002	6.003	6.002	6.002		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>En</i>
Date: <i>07.03.26</i>

Audited by: <i>SA</i>
Date: <i>07.03.26</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF <i>TF</i>	<i>#</i>

